

628022

Dart Aerospace Ltd.

Date: Friday, 09/05/2008 1:43:32 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206L /407 STEP ASSY, RH
Job Number :	39149A		
Estimate Number :	11703		
P.O. Number :		Part Number :	D2724042
This Issue :	09/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2724 REVC
First Issue :	/ /	Project Number :	N/A
Previous Run :	34981A	Drawing Revision :	C
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	30/05/2008
Written By :		Qty:	4
Checked & Approved By :	JUD 08.5.09	Um:	Each
Comment :	Est Rev:E As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B37754 ✓

Check Material for any Dents or Defects

SAD 08/06/12 (4)

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding

SAD 08/06/12 (4)

3.0	D2734	Step End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B39179 ✓

SP 08.09.24 (4)

4.0	D34581	Step Mounting Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	B30408 ✓

SP 08.09.24 (4x)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:43:33 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/407 STEP ASSY, RH

Job Number: 39149A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description
2 D3458-3 Plate

Batch

B36409 = 6. ✓
B35146 = 2 ✓
08.09.24 (4X)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch:

M 108350
M 104855

SP 08.09.25 (4X)

Grind end cap welds flush

SAD 08/09/25 (4)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.09.25 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/25 (+4RH) (4)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FV 08/09/26 (4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 08/09/26 (4)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1




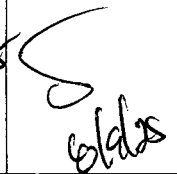
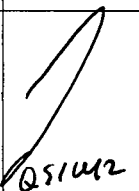
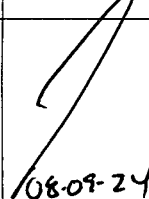

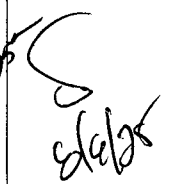
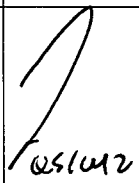
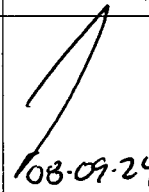
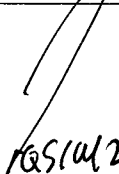
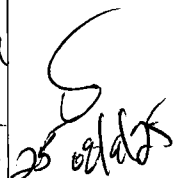
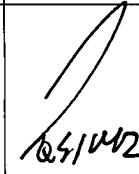
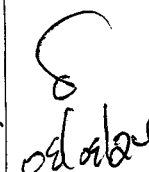
Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

SP 08.09.30 (4X)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3772-2724-042 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 08/18/86
 QA: N/C Closed: _____ Date: _____

NCR: 39149A		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
68-09-24	6-0	Upon Welding, Employee noticed a line going around the extrusion, near the center of the step. Line was also visible on the inside of the step.		- Scrap the step: 4 lugs. - replace Qty 1 step B39316 - Q.C. did not want to take advance on having a defective step in operation.	SP 8.09.25				08-09-24
		R.C. appears to be a stop point from extruding to the supplier.			SP 08.09.25				08-09-24
8/9/24	60	During welding a step grounded itself on the post. causing a Burn through the step R.C. step burned the		Scrap and destroy and replace Qty 1 step B2 39316 AND 4 lugs. AND 1 end cap	SAD 08/09/24				

NOTE: Date & initial all entries moves in stands.

- use Rubber Bungee straps to prevent step from moving in stands

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Job Number: 39149A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: 1104855

SP

08.09.30

(4X)

Grind end plate flush.

SAD

08/09/30

(4X)

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.09.30

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/30 (4X)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

(4X)

Touch up Alodine

M-L

08/04/30

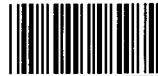
15.0

POWDER COATING

POWDER COATING



M 109152



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

3:20

OVEN TEMPERATURE:

320

FINISH TIME:

3:30

M-L

08/04/30

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/10/01 (4)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

m 109219

FL 08/10/01 (4)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PD 8/12/01 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:43:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 39149A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 39149

PC 8/10/01

(4)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.10.02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

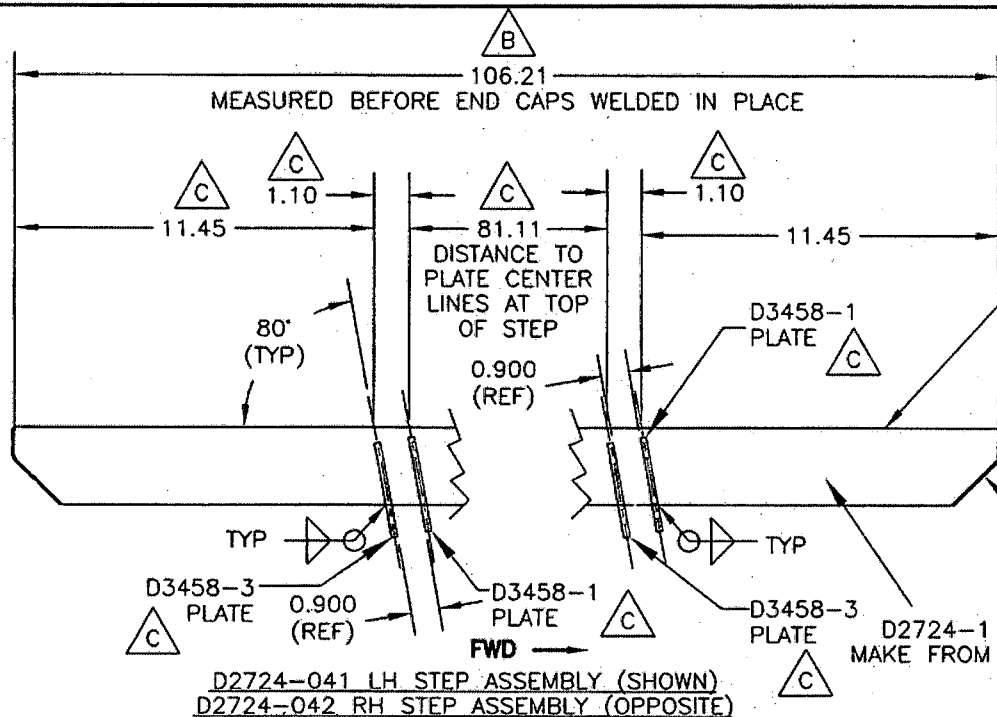
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

RELEASED
05.11.14

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

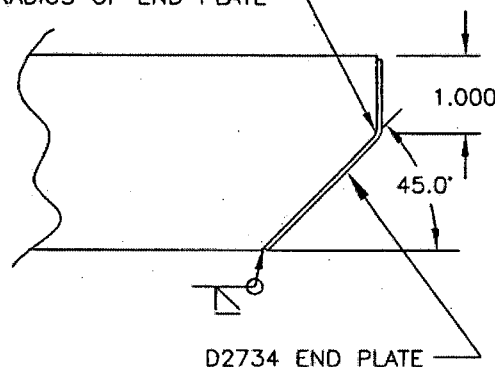


- REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2734 END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- | | | |
|----|---|-----------|
| 1) | MAKE FROM EXTRUSION D2622 | TYPICAL S |
| 2) | WELD PER DART QSI 004 | NOT |
| 3) | FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 | |
| | POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 | |
| | APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4 | |

ALL DIMENSIONS ARE IN INCHES

ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. C
			D2724	SHEET 1 OF 1	
DATE				TITLE	SCALE
05.09.19				206L/407 STEP ASSEMBLY	NTS
A	97.12.04			NEW ISSUE	
B	98.10.19			UPDATED WELD DETAIL REVISED TOLERANCES	
C	05.09.19			RE-DESIGN, ADD D3458-1/-3	

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SUBJECT OF GOVERNMENT
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UNCONTROLLED COPY
OF THE
SUBJECT OF THE REMINDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3112974

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries